

FIG. 1

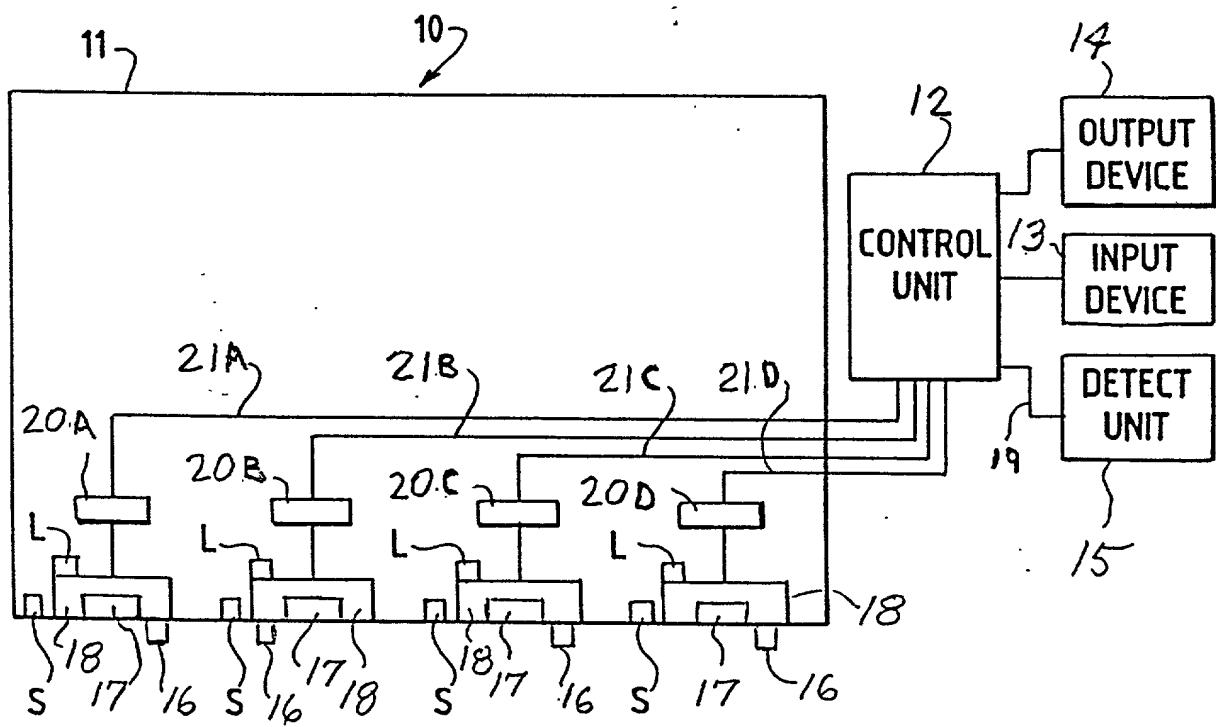


FIG. 2A

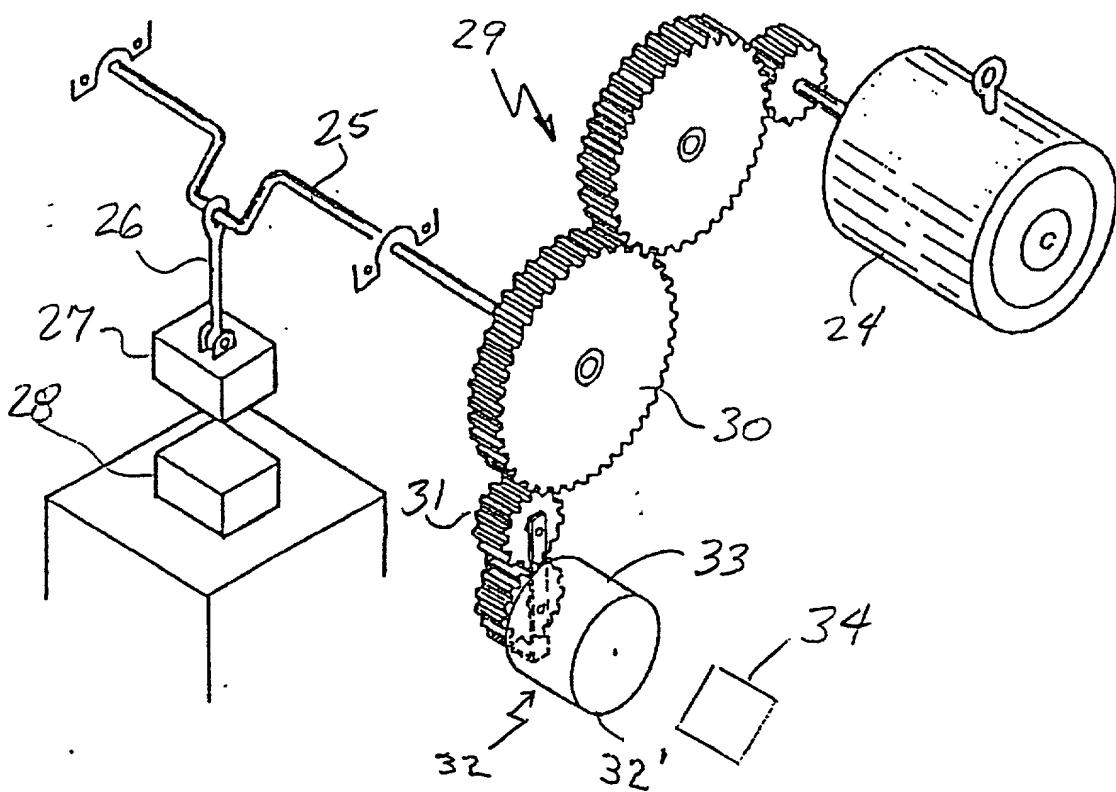


FIG. 2B

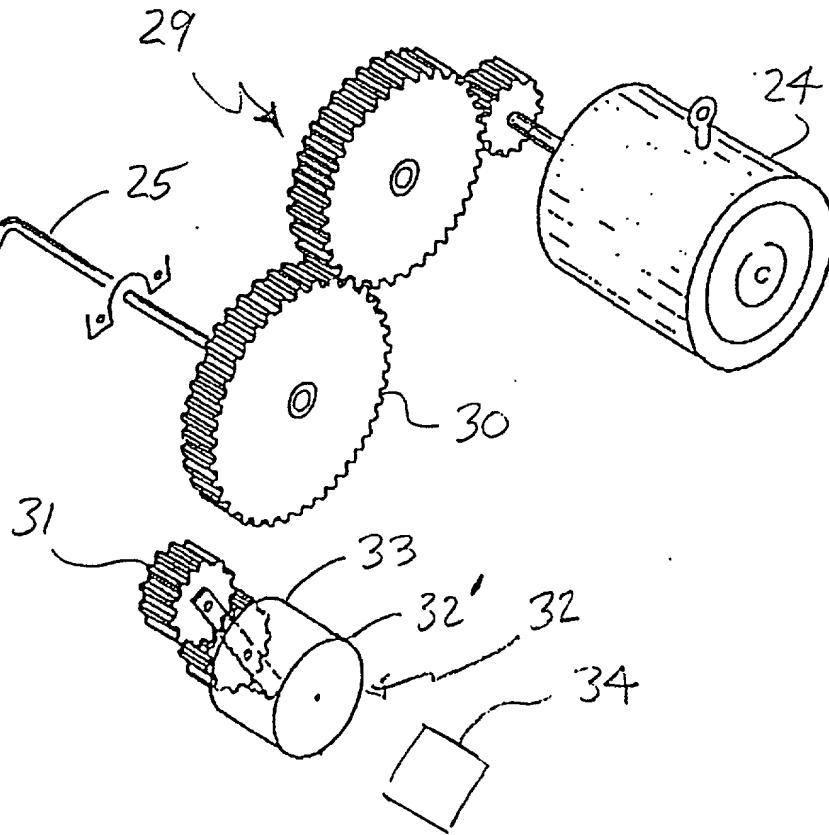


FIG. 3

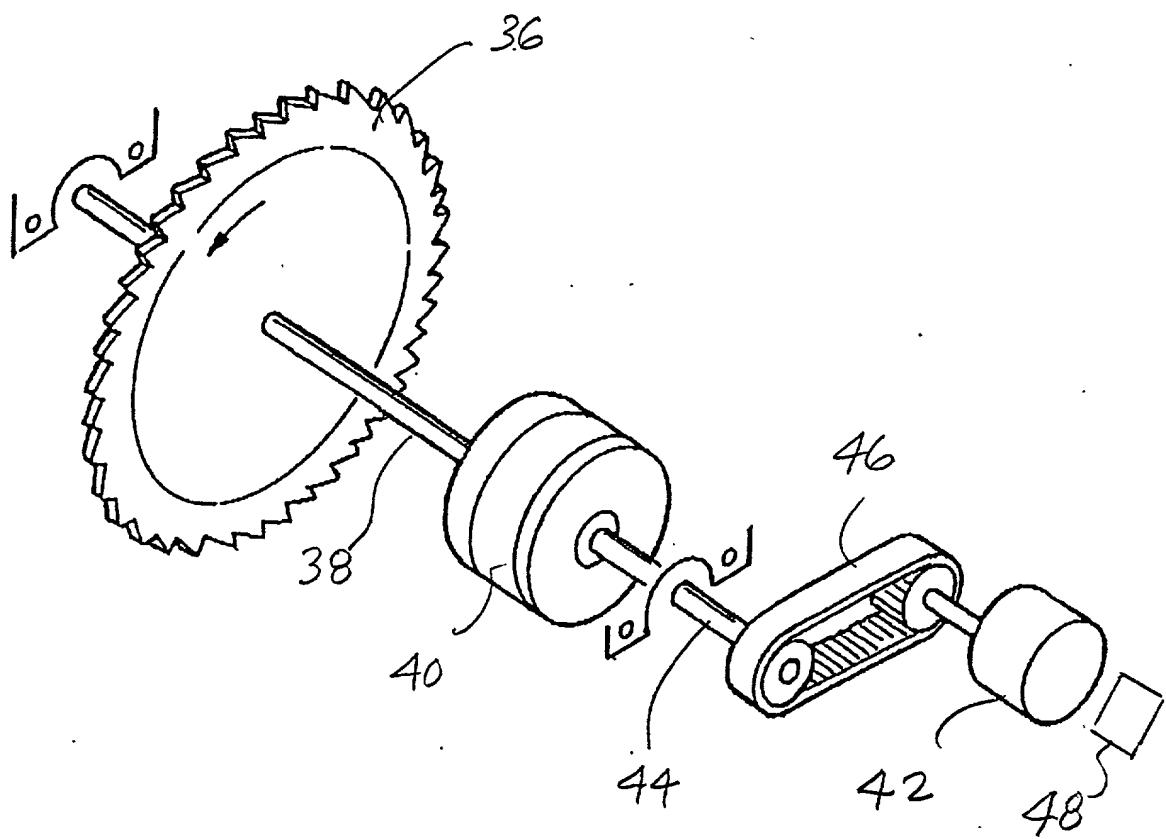


FIG. 4 ZERO SPEED INDICATOR TEST SUBROUTINE
IN SITU TESTING WHILE THE MACHINE IS RUNNING

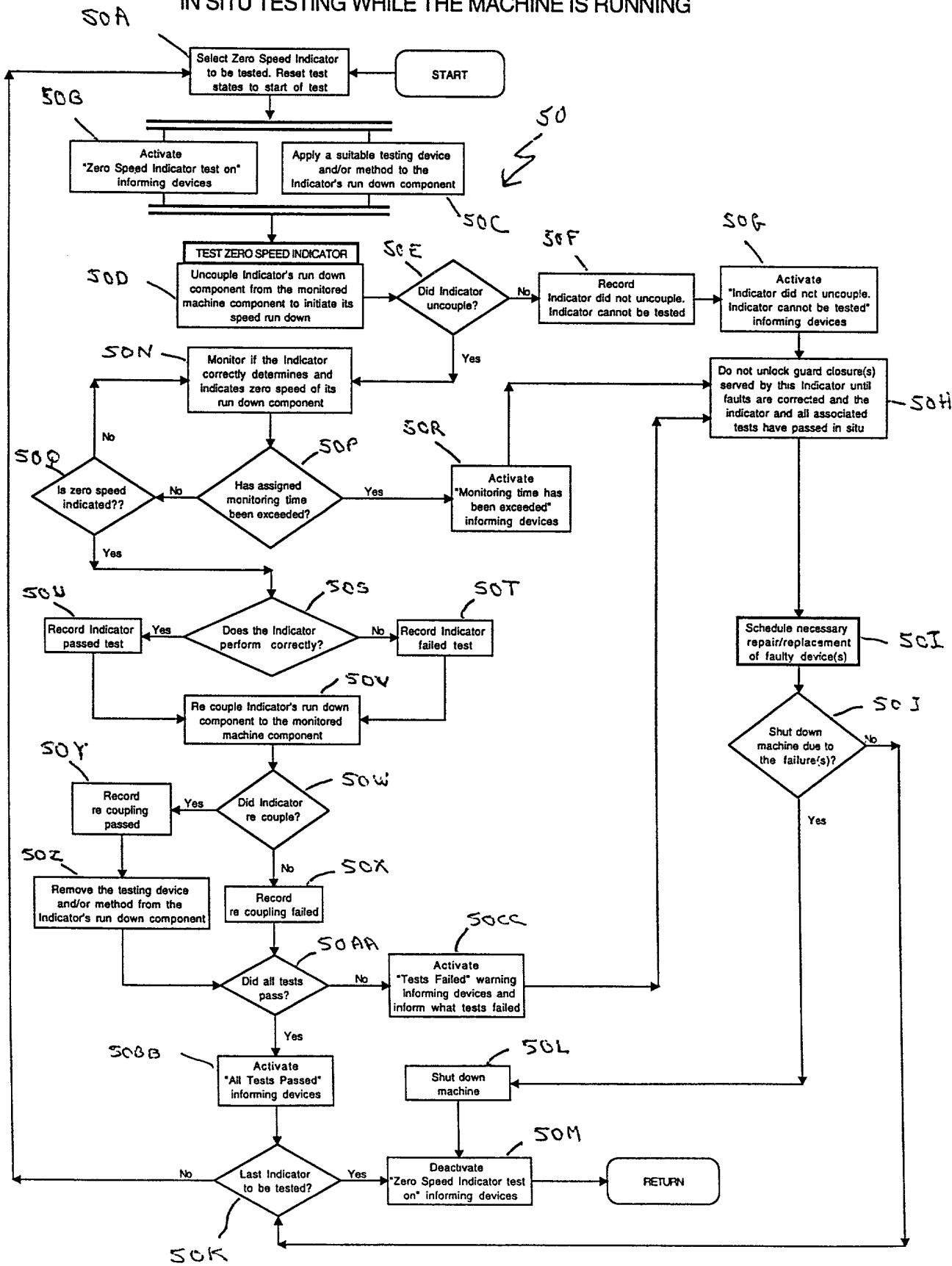
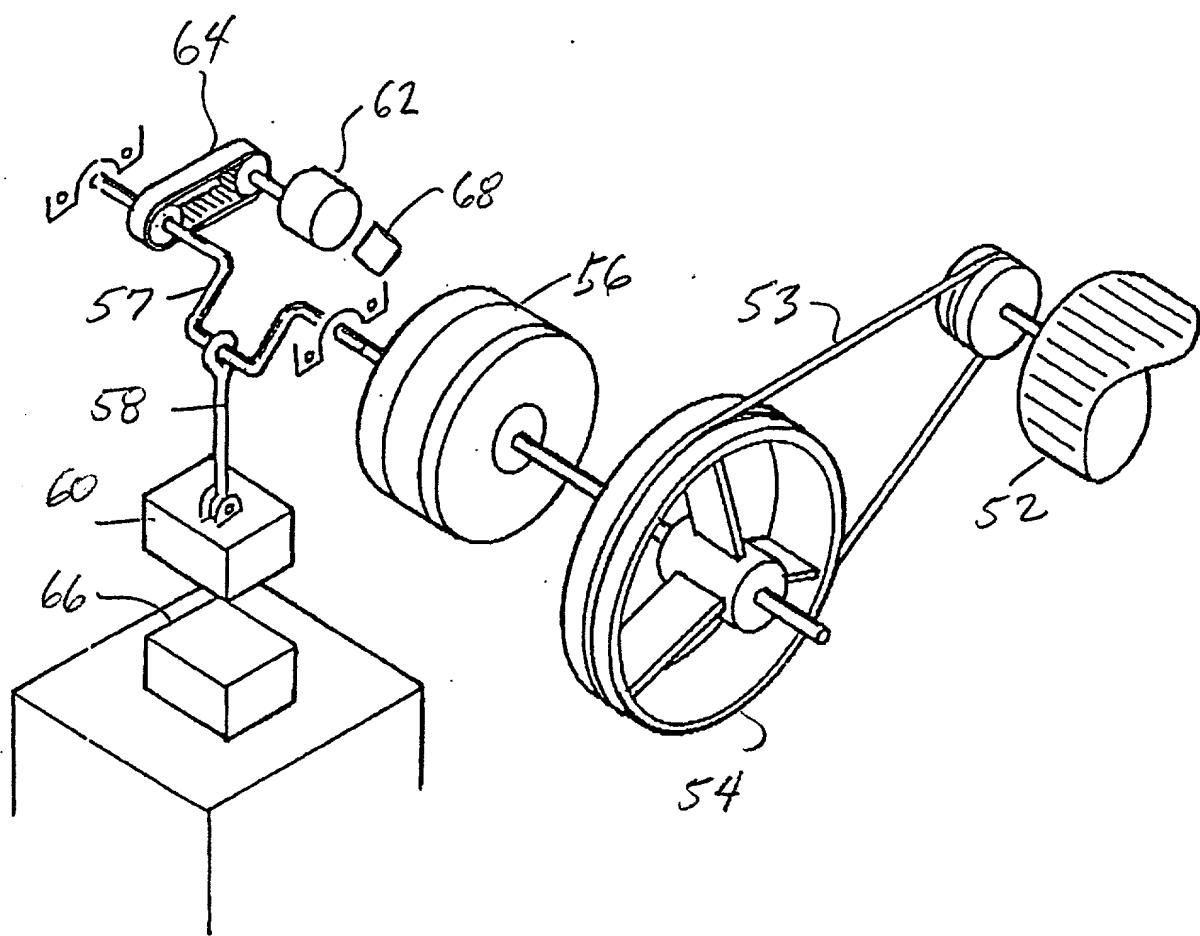
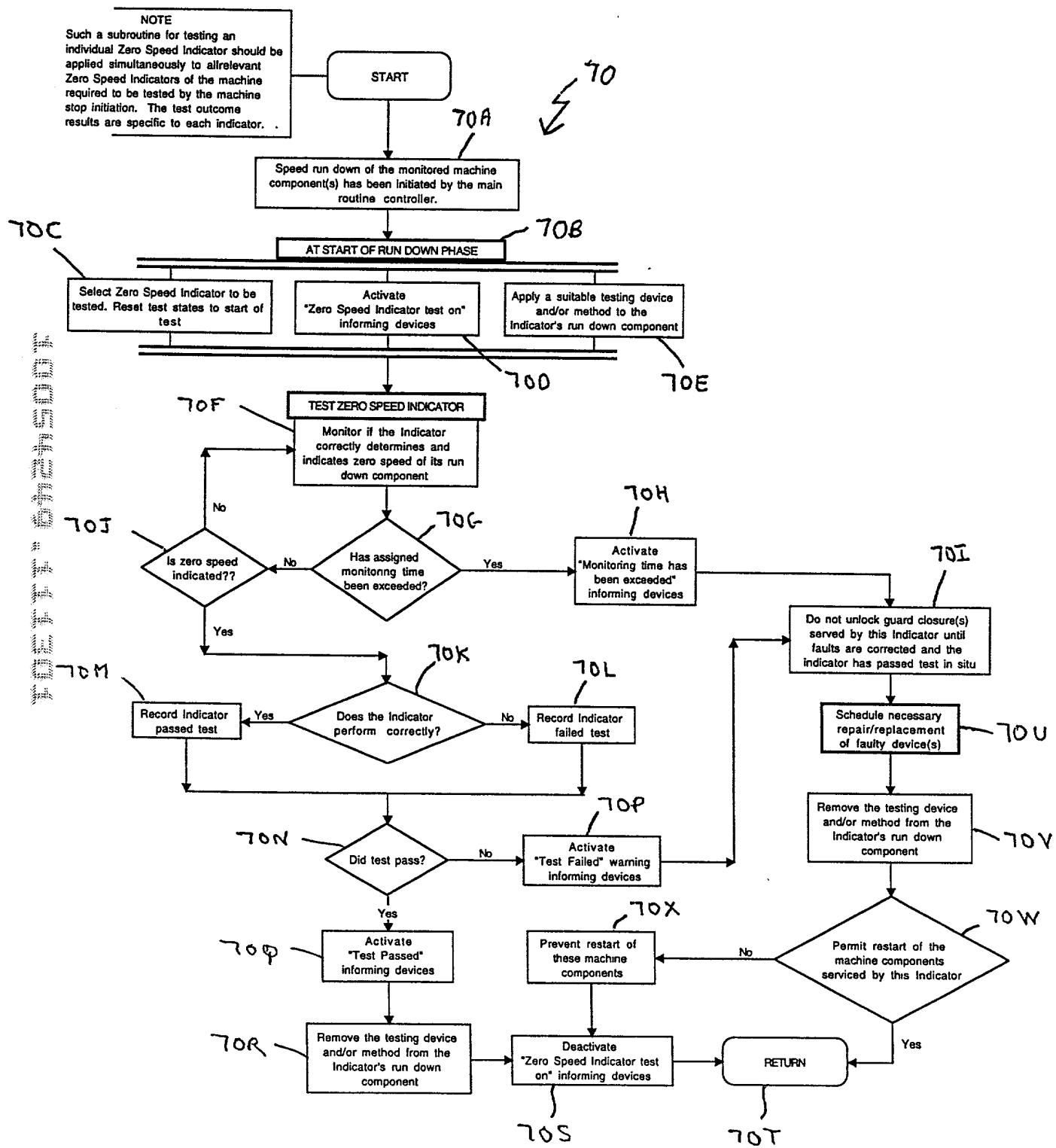


FIG. 5



**FIG. 6 ZERO SPEED INDICATOR TEST SUBROUTINE
IN SITU TESTING DURING THE SPEED RUN DOWN PHASES
CAUSED BY MACHINE STOP INITIATIONS**



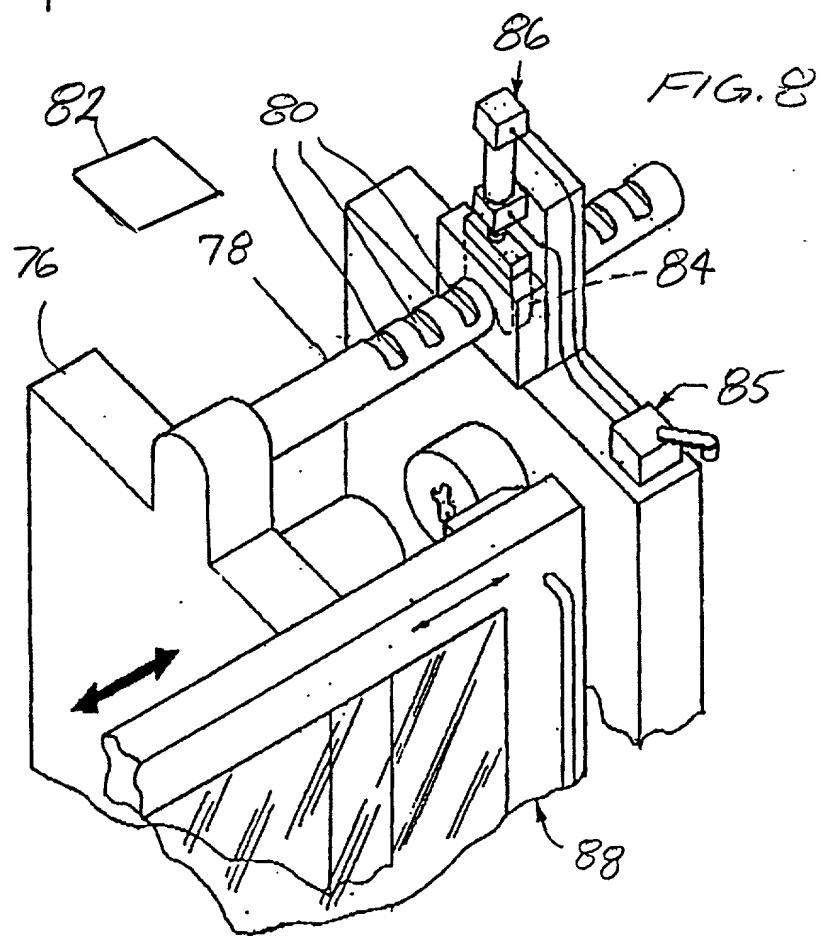
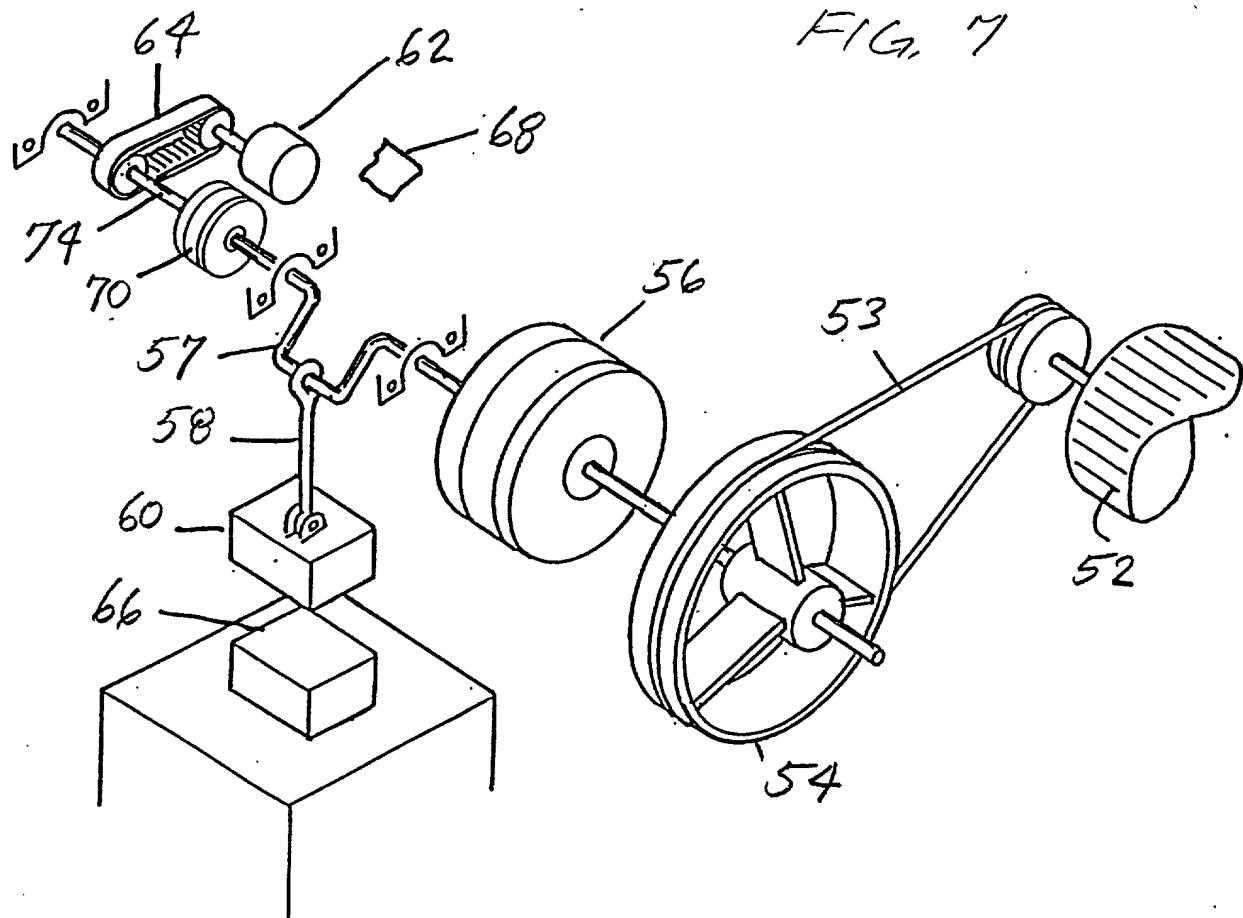


FIG. 9 SUBROUTINE FOR INSERTION OF A MOTION
INTERFERENCE DEVICE AT SPEED RUN DOWN COMPLETION
CAUSED BY MACHINE STOP INITIATIONS

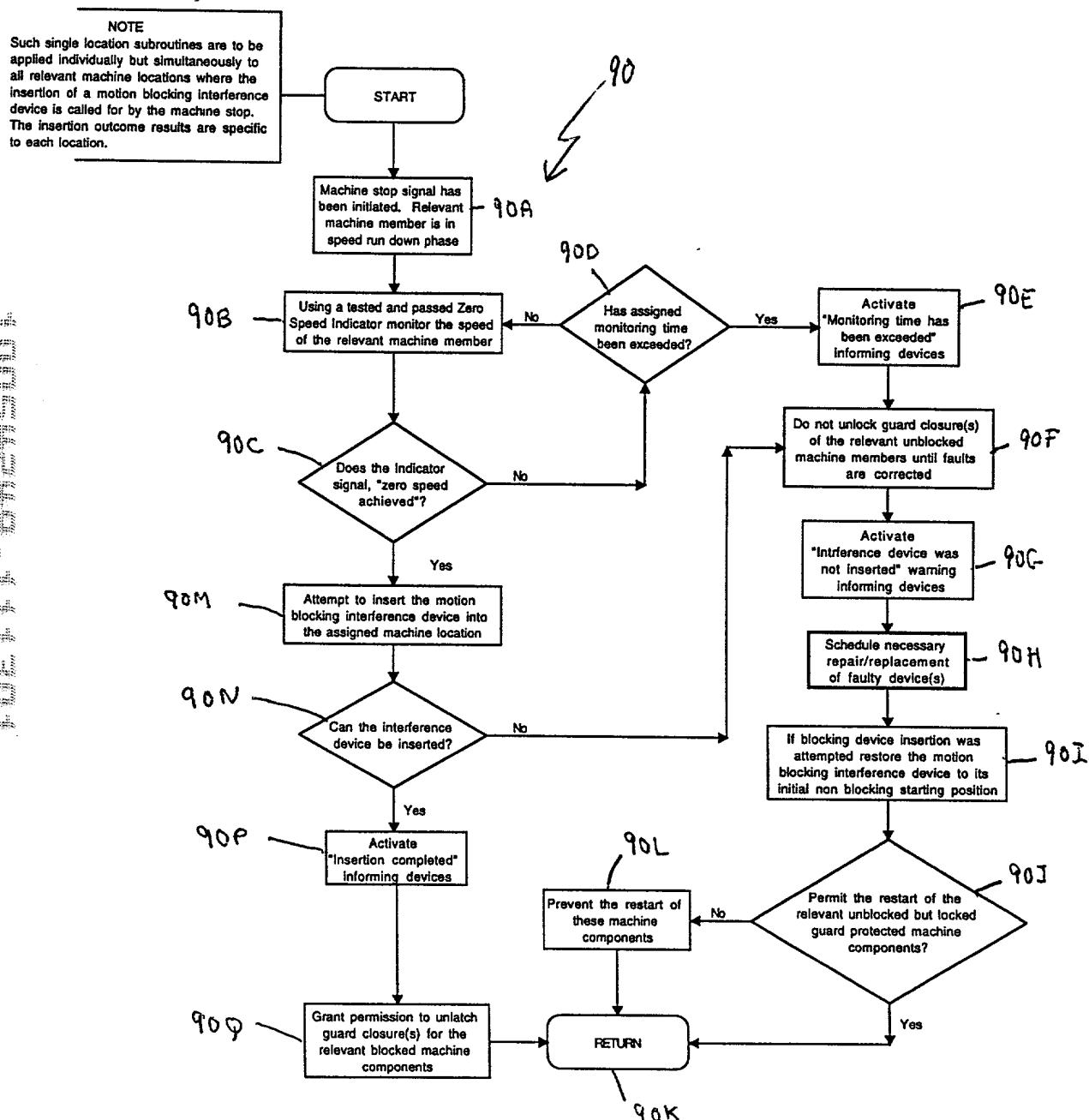


FIG. 10 SUBROUTINE FOR CHECKING THE FULFILLMENT OF NECESSARY CONDITIONS FOR UNLATCHING A GUARD CLOSURE

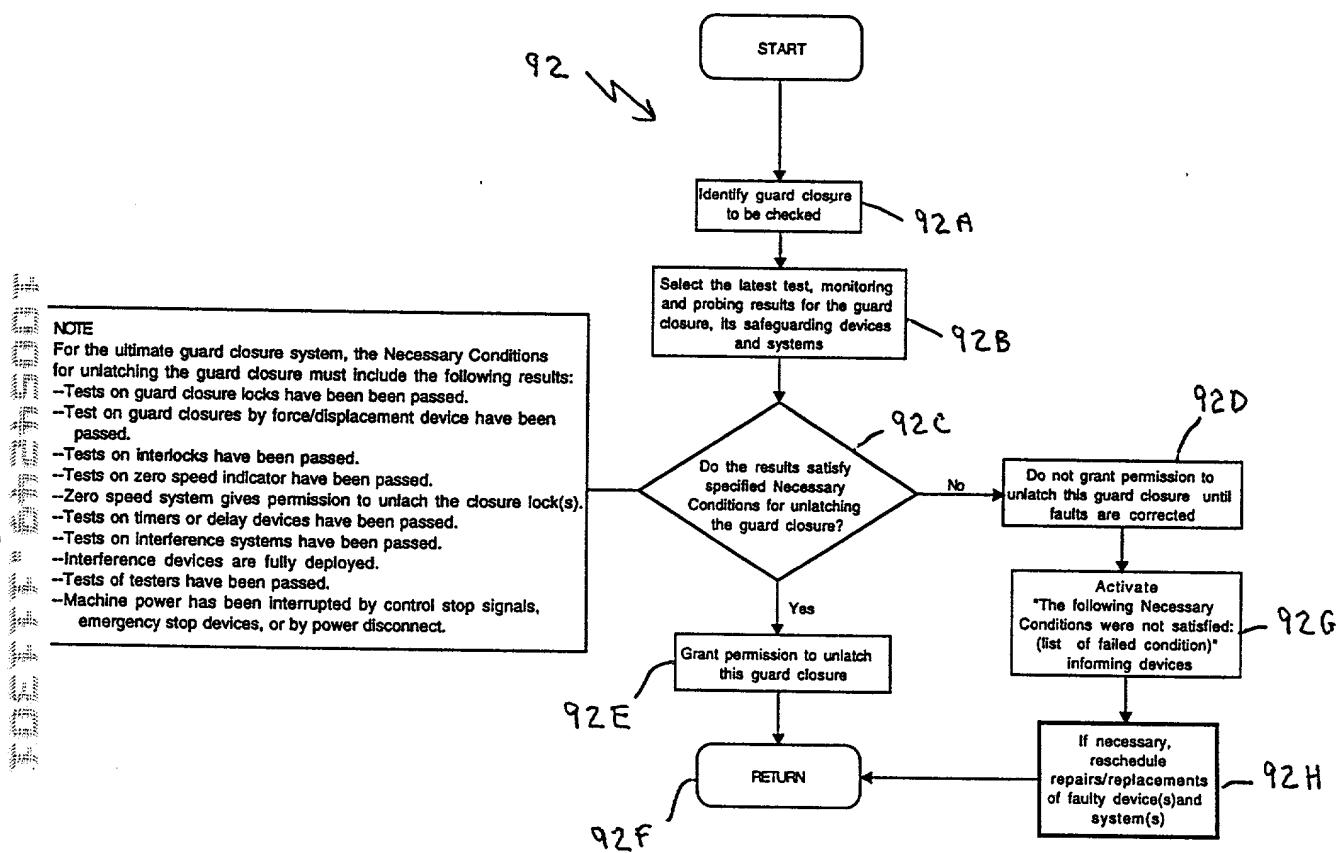


FIG. 11A EXAMPLE MAIN ROUTINE
FOR TESTING SAFEGUARDING DEVICES AND
SYSTEMS FOR GUARD CLOSURES

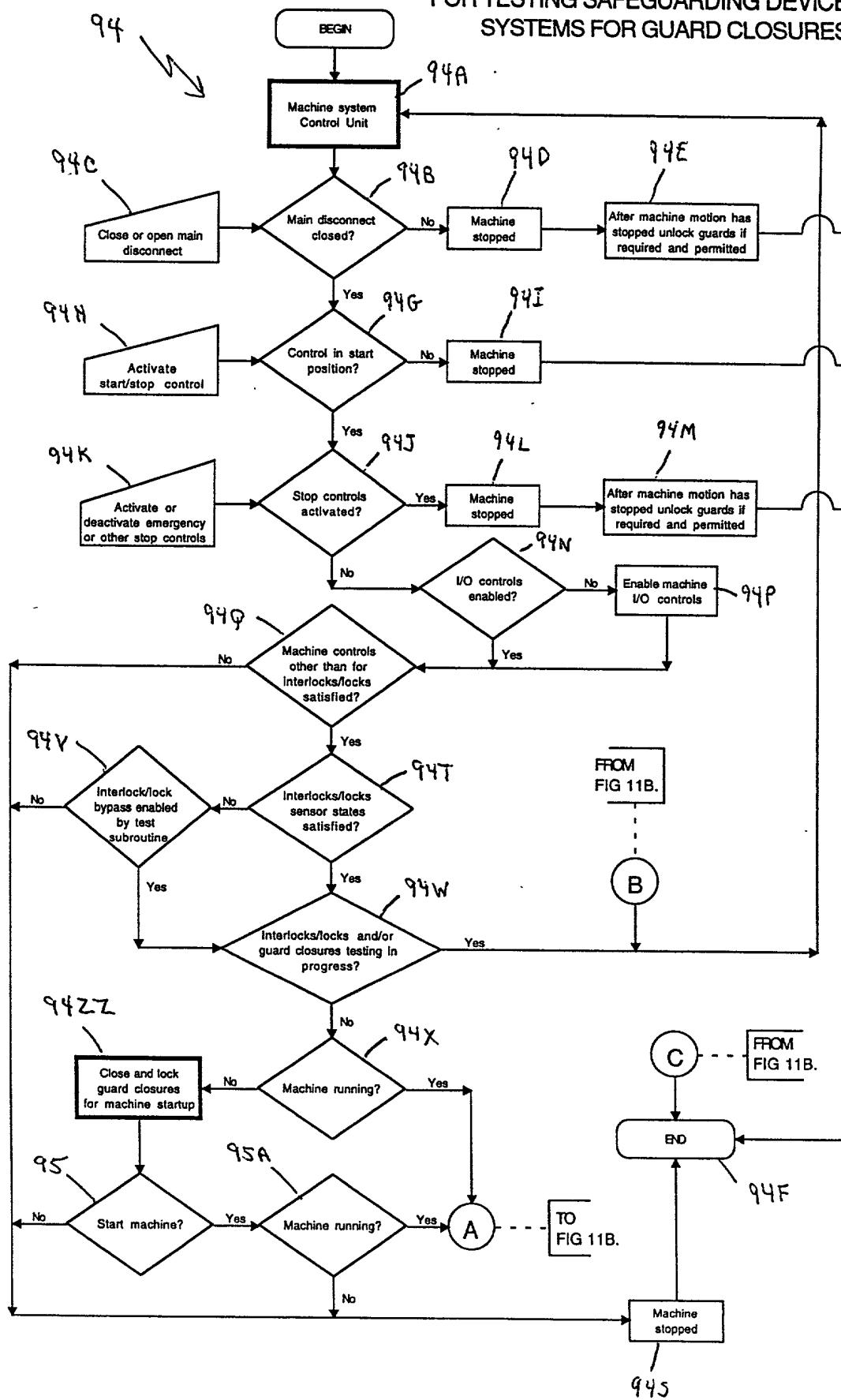


FIG. 118 EXAMPLE MAIN ROUTINE FOR TESTING SAFEGUARDING DEVICES AND SYSTEMS FOR GUARD CLOSURES

